

Date: Friday, 18/07/2008 2:42:29 PM  
User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	HELI ACCESS STEP EXT HIGH GEAR RH
<b>Job Number</b> :	40670		
<b>Estimate Number</b> :	12875		
<b>P.O. Number</b> :		<b>Part Number</b> :	D205633026
<b>This Issue</b> :	18/07/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	DSI 9300 REV B
<b>First Issue</b> :	1/1	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	34976	<b>Drawing Revision</b> :	B
	<b>Type</b> :	<b>Material</b> :	
	LARGE FAB ASSY	<b>Due Date</b> :	28/07/2008
<b>Written By</b> :		<b>Qty:</b>	2 Um: Each
<b>Checked &amp; Approved By</b> :	<i>JUD 08.7.18</i>		
<b>Comment</b> :	Est Rev:B Added D3165-1 KJ/JLM 05-09-09		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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*JUD 08.7.23***Comment:** DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPPD205-633-026

CHG001

*Soc 4/25*

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D2022101	Spacer
-----	----------	--------

**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Spacer

Batch: *21505 6x B23396 2x*

4.0	D2022103	Spacer
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spacer

Batch: *16062*

5.0	D2562005	Strut
-----	----------	-------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Strut

Batch: *23 224 3**1/2 3 @*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 18/07/2008 2:42:30 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP EXT HIGH GEAR RH

Job Number: 40670

Part Number: D205633026

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D3438042

Step Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Step Weldment Assembly

Batch: 40668

1-8/2/25 @

7.0

D31651

Support Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Support Arm

Batch: 20617 1X

34988 1X

W

8.0

D2565301

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Strut

Batch: 20848 1X

23226 1X

W

9.0

D2565303

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Strut

Batch: 20609 1X

20849 1X

W

10.0

D2565305

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Strut

Batch: 20850 1X

17672 1X

W

11.0

D2565307

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Strut

Batch: 20851 1X

23229 1X

W

12.0

D2565309

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Strut

Batch: 20612 X1

20852 1X

1-8/7/23 @

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 18/07/2008 2:42:30 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP EXT HIGH GEAR RH

Job Number: 40670

Part Number: D205633026

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D3437045

Aft Strut Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Aft Strut Assembly

Batch: B335498

14.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M106605

15.0

AN46A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Batch: M16067

16.0

AN47A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M16199

17.0

AN412A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M108143

18.0

AN414A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M107834

19.0

AN44 7A

EYEBOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

EYEBOLT

Batch: M17614 1x M17683 7x

\*\*\*\*\*ENSURE THIS IS AN44-7A EYEBOLT\*\*\*\*\*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: HELI ACCESS STEP EXT HIGH GEAR RH

Job Number: 40670

Part Number: D205633026

Job Number:



Seq. #: Machine Or Operation: Description :

20.0 AN514A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M16947 M164547

21.0 AN960JD416 Washer



Comment: Qty.: 14.0000 Each(s)/Unit Total: 28.0000 Each(s)

Washer

Batch: M16941

22.0 AN960JD516 Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Washer

Batch: M18104Y M107959 2P

23.0 MS21042L4 Nut



Comment: Qty.: 7.0000 Each(s)/Unit Total: 14.0000 Each(s)

Nut

Batch: M15924 6Y M17997 8Y

24.0 MS21042L5 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: M107939

25.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-633-026

Location:

PPP Rev:

DRAFT 0

AS 0807/25 (X2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Friday, 18/07/2008 2:42:30 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP EXT HIGH GEAR RH

Job Number: 40670

Part Number: D205633026

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/25 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-07-25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9300	REV. B SHEET 1 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS
A	05.05.05	NEW ISSUE	
B	05.08.12	ADD STRUTS IF TANK REMOVED	

## DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-633 REV. A

REF. CANADIAN STC: SH96-57

REF. FAA STC: SR00592NY, SR00593NY, SR00594NY

THE PURPOSE OF THIS SERVICE INSTRUCTION IS TO ADD THE D205-633-021/-022/-023/-024/-025/-026 STEPS TO ADDRESS COMPATABILITY WITH THE SIMPLEX MODEL 304 FIRE ATTACK TANK. D205-633-021/-022 ARE IDENTICAL TO D205-633-011, EXCEPT AS SHOWN HERE. D205-633-023/-024 ARE IDENTICAL TO D205-633-013, EXCEPT AS SHOWN HERE. D205-633-025/-026 ARE IDENTICAL TO D205-633-015, EXCEPT AS SHOWN HERE.

NOTE THAT THE STRUTS REQUIRED TO INSTALL THE STEPS ON THE LOWER AFT HARDPOINT HAVE ALSO BEEN INCLUDED WITH THE KITS IN CASE THE TANK IS REMOVED FOR ANY REASON. THESE STRUTS SHOULD BE INSTALLED I.A.W. IIN-D205-633, EXCEPT REPLACE EYEBOLT WITH AN4 BOLT ON LOWER HARDPOINT. ALSO NOTE THAT IF THE THREADS PROTRUDE THROUGH THE BAR ON THE D3437-XXX STRUT ASSEMBLIES AFTER ADJUSTMENT THEY MAY BE TRIMMED OFF.

### WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-633-021	14.0 lb	-50.0 in	-700 in lb	94.5 in	1323 in lb
HELI-ACCESS-STEP™	6.35 kg	-1.27 m	-8.06 m kg	2.40 m	15.24 m kg
D205-633-022	13.2 lb	+50.0 in	+660 in lb	94.5 in	1247 in lb
HELI-ACCESS-STEP™	6.00 kg	+1.27 m	+7.62 m kg	2.40 m	14.40 m kg
D205-633-023	14.3 lb	-50.0 in	-715 in lb	94.5 in	1351 in lb
HELI-ACCESS-STEP™	6.50 kg	-1.27 m	-8.26 m kg	2.40 m	15.6 m kg
D205-633-024	13.5 lb	+50.0 in	+675 in lb	94.5 in	1276 in lb
HELI-ACCESS-STEP™	6.14 kg	+1.27 m	+7.80 m kg	2.40 m	14.74 m kg
D205-633-025	14.6 lb	-50.0 in	-730 in-lb	94.5 in	1380 in-lb
HELI-ACCESS-STEP™	6.64 kg	-1.27 m	-8.43 m-kg	2.40 m	15.94 m-kg
D205-633-026	13.8 lb	+50.0 in	+690 in-lb	94.5 in	1304 in-lb
HELI-ACCESS-STEP™	6.27 kg	+1.27 m	+7.96 m-kg	2.40 m	15.05 m-kg

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40670

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED 	
BY:	D. SHEPHERD (DE # 02)
DATE:	05.08.12
CERT. NO.:	SH96-57
ISSUE NO.:	#5

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CHECKED 	APPROVED 	DRAWING NO. DSI 9300	REV. B SHEET 2 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS

### PARTS LIST

QTY -021	QTY -022	QTY -023	QTY -024	QTY -025	QTY -026	Part Number	Description
X						D205-633-021	Heli-Access-Step™ (LH), High Gear
	X					D205-633-022	Heli-Access-Step™ (RH), High Gear
		X				D205-633-023	Heli-Access-Step™ (LH), Extended High Gear (31")
			X			D205-633-024	Heli-Access-Step™ (RH), Extended High Gear (31")
				X		D205-633-025	Heli-Access-Step™ (LH), Extended High Gear (39")
					X	D205-633-026	Heli-Access-Step™ (RH), Extended High Gear (39")
4	4	4	4	4	4	D2022-101	SPACER
2	2	2	2	2	2	D2022-103	SPACER
				1	1	D2562-005	STRUT
1	1					D2562-011	STRUT
		1	1			D2562-013	STRUT
1		1		1		D2563	WELDMENT ASSEMBLY
				*1	*1	D3165-1	STRUT
1	1					D2565-101	STRUT
1	1					D2565-103	STRUT
1	1					D2565-105	STRUT
1	1					D2565-107	STRUT
1	1					D2565-109	STRUT
*1	*1					D2565-111	STRUT
		1	1			D2565-201	STRUT
		1	1			D2565-203	STRUT
		1	1			D2565-205	STRUT
		1	1			D2565-207	STRUT
		1	1			D2565-209	STRUT
		*1	*1			D2565-211	STRUT
				1	1	D2565-301	STRUT
				1	1	D2565-303	STRUT
				1	1	D2565-305	STRUT
				1	1	D2565-307	STRUT
				1	1	D2565-309	STRUT
1	1					D3437-041	AFT STRUT ASSEMBLY
		1	1			D3437-043	AFT STRUT ASSEMBLY
				1	1	D3437-045	AFT STRUT ASSEMBLY
	1		1		1	D3438-042	WELDMENT ASSEMBLY
1	1	1	1	1	1	AN4-5A	BOLT
4	4	3	3	3	3	AN4-6A	BOLT
1	1	1	1	1	1	AN4-7A	BOLT
1	1					AN4-11A	BOLT
		1	1	1	1	AN4-12A	BOLT
1	1	1	1	1	1	AN4-14A	BOLT
1	1	1	1	1	1	AN44-7A	EYEBOLT
1	1	1	1	1	1	AN5-14A	BOLT
16	16	14	14	14	14	AN960JD416	WASHER
3	3	3	3	3	3	AN960JD516	WASHER
8	8	7	7	7	7	MS21042L4	NUT (or MS21042-4)
2	2	2	2	2	2	MS21042L5	NUT (or MS21042-5)

\* ONLY INSTALLED IF TANK IS REMOVED

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED SHOP COPY  
BY: RETURN TO  
D. SHEPHERD (DE # 02) ENGINEERING  
UNCONTROLLED COPY  
DATE: 05.08.12 SUBJECT TO AMENDMENT  
CERT. NO.: SH96-57 WITHOUT NOTICE  
ISSUE NO.: #5 WORK ORDER  
NO. 90670

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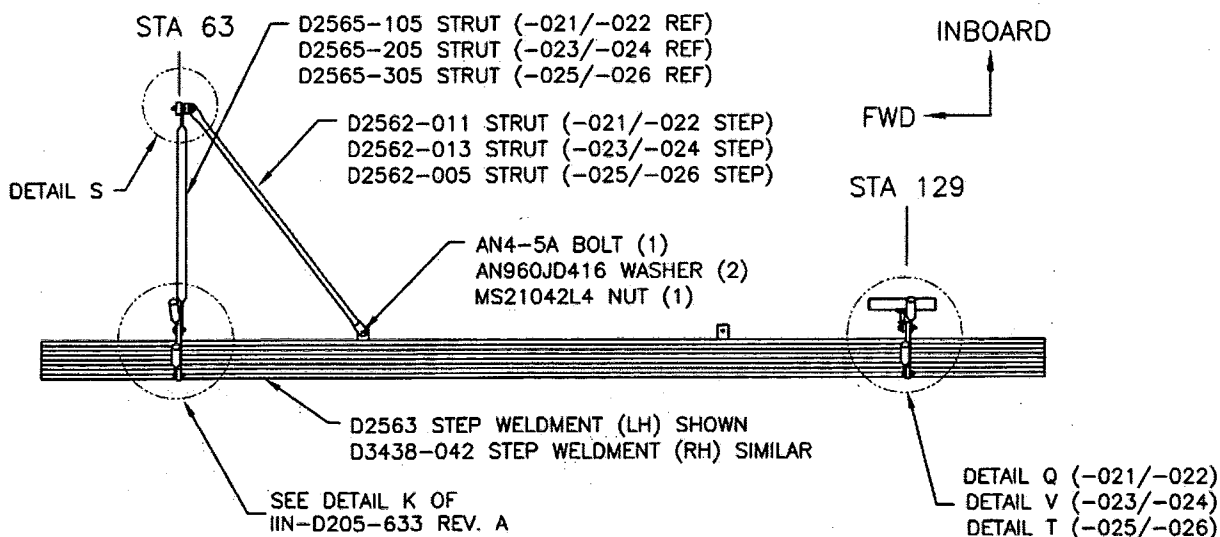
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9300	REV. B 3 OF 6
DATE 05.08.12	TITLE SIMPLEX TANK STEP KIT		SCALE NTS

### INSTALLATION OF D205-633-021/-022/-023/-024/-025/-026

INSTALL D205-633-021/-022 AS PER THE D205-633-011 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D2565-111 STRUT WITH THE D3437-041 AFT STRUT ASS'Y, REMOVE D2562-001 STRUT, INSTALL D2562-011 STRUT AS SHOWN.

INSTALL D205-633-023/-024 AS PER THE D205-633-013 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D2565-211 STRUT WITH THE D3437-043 AFT STRUT ASS'Y, REMOVE D2562-003 STRUT, INSTALL D2562-013 STRUT AS SHOWN.

INSTALL D205-633-025/-026 AS PER THE D205-633-015 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D3165-1 SUPPORT ARM WITH THE D3437-045 AFT STRUT ASS'Y AS SHOWN.



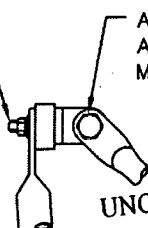
**D205-633-021/-023/-025 SHOWN.**

**D205-633-022/-024/-026 SIMILAR**

(VIEW LOOKING DOWN)

AN44-7A EYEBOLT (1)  
AN960JD516 WASHER (1)  
MS21042L5 NUT (1)

**DETAIL S**  
NOT TO SCALE



AN4-6A BOLT (1)  
AN960JD416 WASHER (2)  
MS21042L4 NUT (1)  
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WORK ORDER  
NO. 40670

CANADA  
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AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

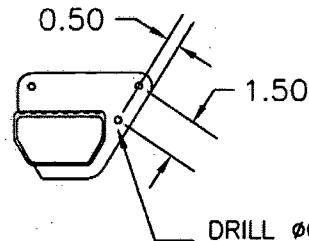
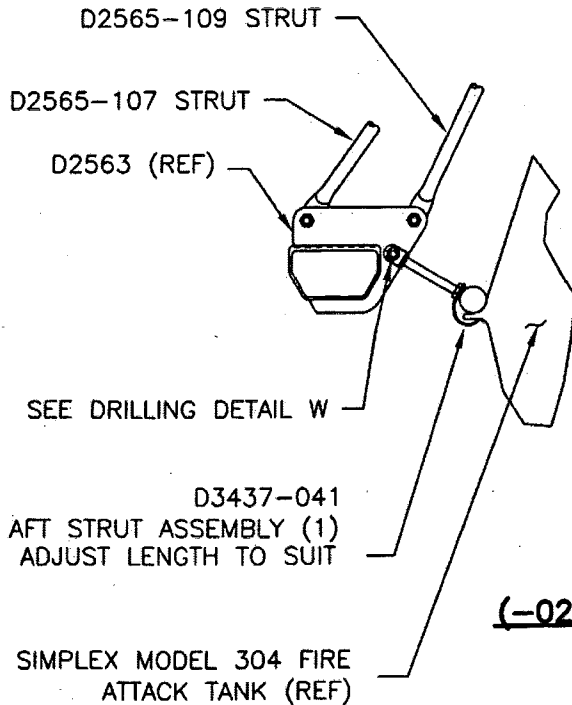
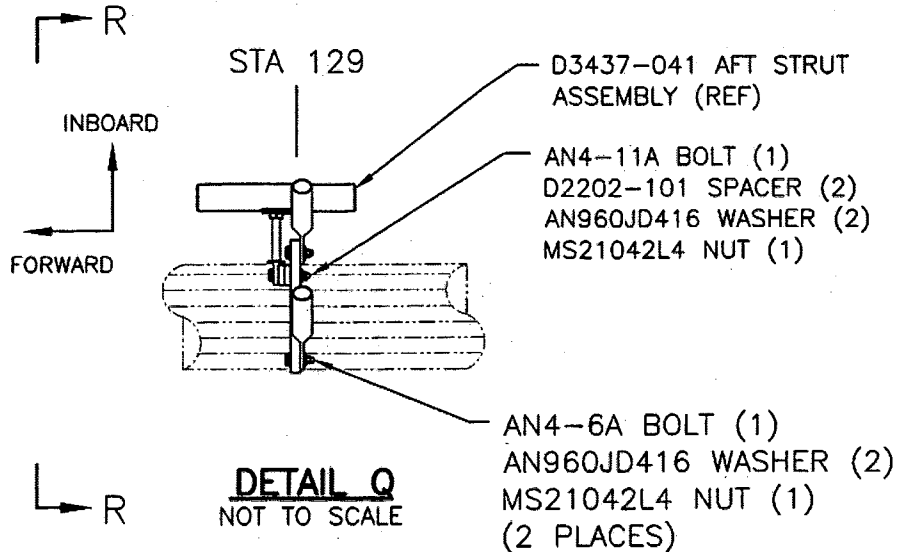
DATE: 05.08.12  
CERT. NO.: SH96-57  
ISSUE NO.: #5

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**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9300	REV. B SHEET 4 OF 6
DATE 05.08.12	TITLE SIMPLEX TANK STEP		SCALE NTS

**DETAIL W**

DRILL  $\phi 0.257$  THRU,  
TOUCH UP WITH  
ALODINE 1200 OR 1201  
PER MIL-C-5541 AS SHOWN

SHOP COPY  
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**(-021/-022 STEP)**  
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**VIEW R-R**  
NOT TO SCALE NO. *40070*

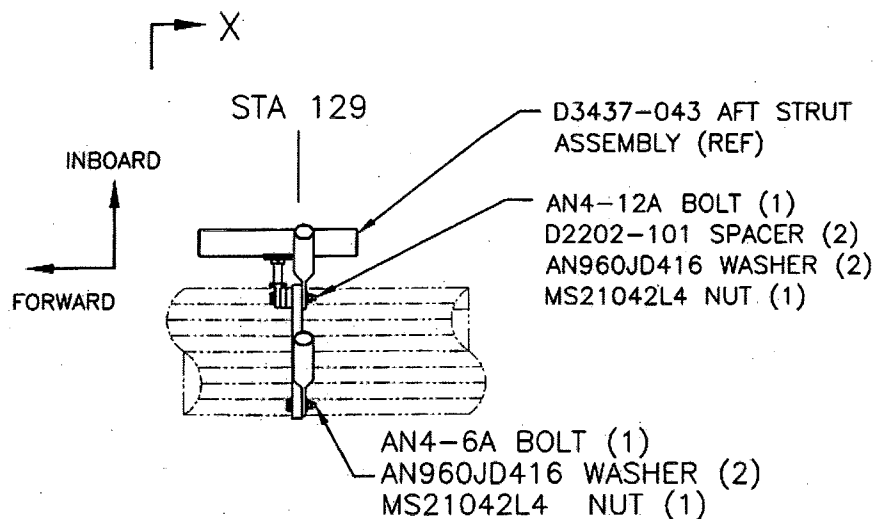
CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO #01-Q-01	
APPROVED <i>[Signature]</i>	
BY:	D. SHEPHERD (DE #02)
DATE:	05.08.12
CERT. NO.:	SH98-57
ISSUE NO.:	#5

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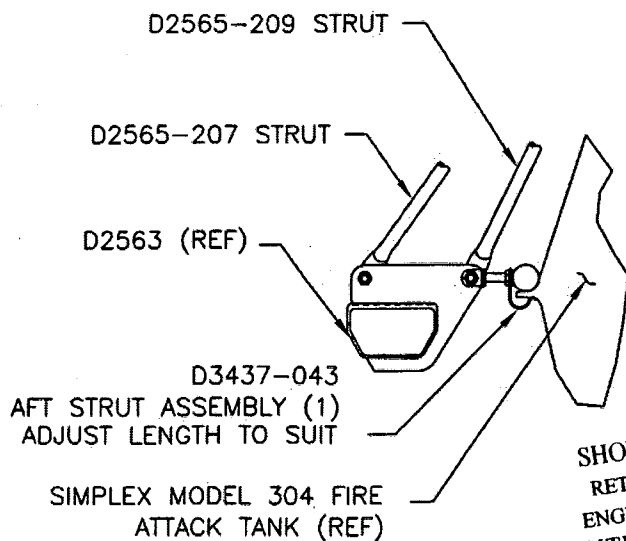
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9300	REV. B SHEET 5 OF 6
DATE 05.08.12	TITLE SIMPLEX TANK STEP		SCALE NTS



**DETAIL V**  
NOT TO SCALE



**(-023/-024 STEP)**

**VIEW X-X**  
NOT TO SCALE

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *[Signature]*

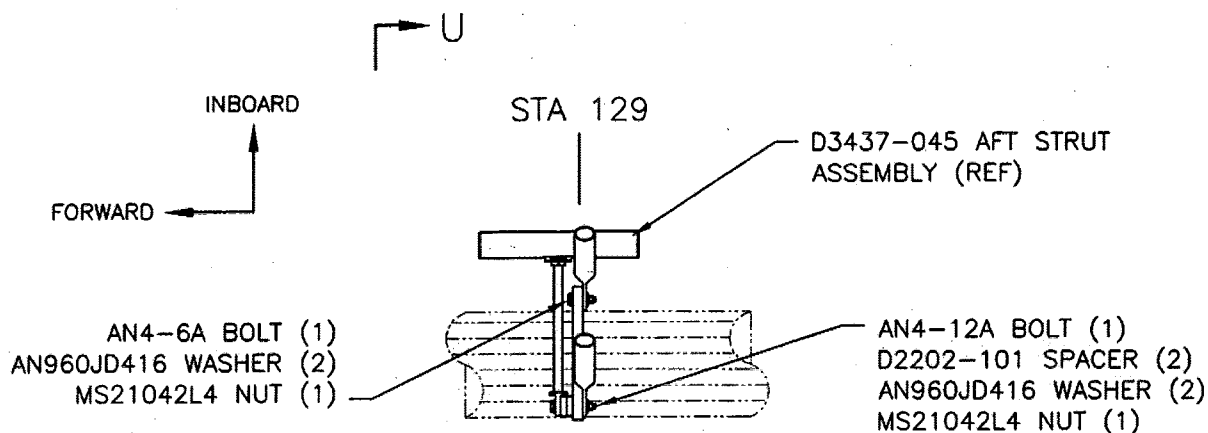
CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
<b>APPROVED</b> <i>[Signature]</i>	
BY:	D. SHEPHERD (DE # 02)
DATE:	05.08.12
CERT. NO.:	SH96-57
ISSUE NO.:	#5

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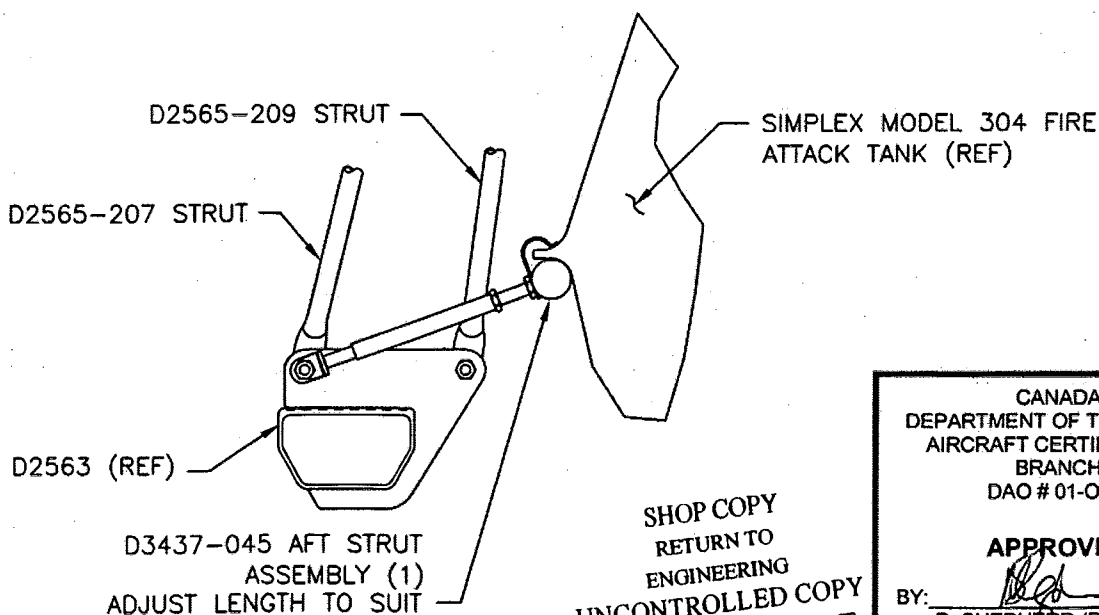


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